

Work Order ID 137956

October 16, 2015 11:42:53 AM

137956

Page 1

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Upper Rib Assembly
Start Date: 10/16/2015 Start Qty: 2.00 ***2*** **3x** Cust Item ID:
Required Date: 10/30/2015 Req'd Qty: 2.00 ***0*** Customer:
Reference:

Approvals: Process Plan: 54 Date: 20151016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	C								

100 Weld per dwg A/R S.S. rod Batch: 3132768 0.00

100

Large Fab

Large Fab

Memo

0.02

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

3x CC 15-1021

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

3 AUG 21 2015 DAS
24
9-89

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

3 AUG 21 2015 DAS
24
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence					
				OTHER : _____					

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Page 2

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Aft Upper Rib Assembly
Start Date: 10/16/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/30/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>W/A 004</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION: WA004								<i>3x CC 15-10-21</i>
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							<i>MC OCT 22 2015</i>
Quality Control									

SA 20151022

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : ☐							

Picklist Print

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Work Order ID: 137956

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Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 10/16/2015

Required Date: 10/30/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
DWG REV.B DD VERF:EC
REV.pc1 DD VERF:JLM
IPP Rev:B as
IPP Rev:C 11.01.19 AS PER
IPP Rev:D 13.03.14 AS PER DWG
IPP REV:E 13.06.21 DWG REV.C DD
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4034-1 Rib		Manufactured	No			100	Each	6.0000	1	2			
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D4034-1 ** CC 15-10-21

Location	Loc Qty	Loc Code
WA004	6	
137825	6	

D4034-3 Rib		Manufactured	No			100	Each	10.0000	1				
----------------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

D4034-3 ** CC 15-10-21

Location	Loc Qty	Loc Code
WA	8	
135226	8	
WA004	2	
135905	2	

D4021-7 Hoop		Manufactured	No			100	Each	1.0000	1				
-----------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

D4021-7 ** CC 15-10-21

Location	Loc Qty	Loc Code
WA004	1	
135523	1	

B136581 →

Picklist Print

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Work Order ID: 137956

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Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 10/16/2015

Required Date: 10/30/2015

Start Qty: 2.00

Required Qty: 2.00

D4021-9

Manufactured No

100

Each

124.0000

4

8

D4021-9

Bushing

CC 15-10-21

Location

Loc Qty

Loc Code

WA004

124

120334

2

122601

4

136850

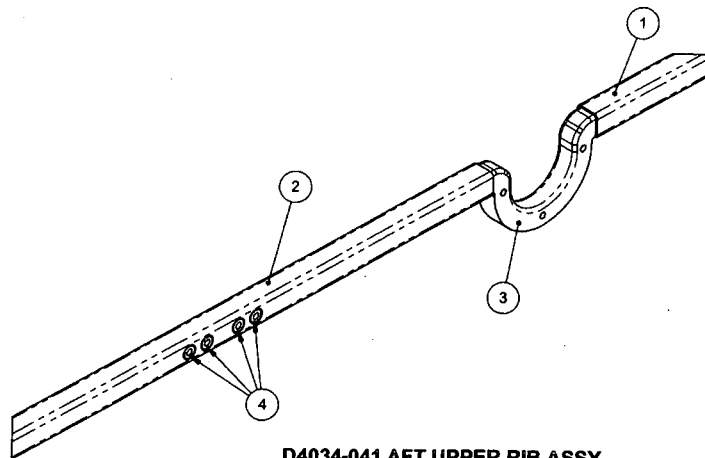
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137201

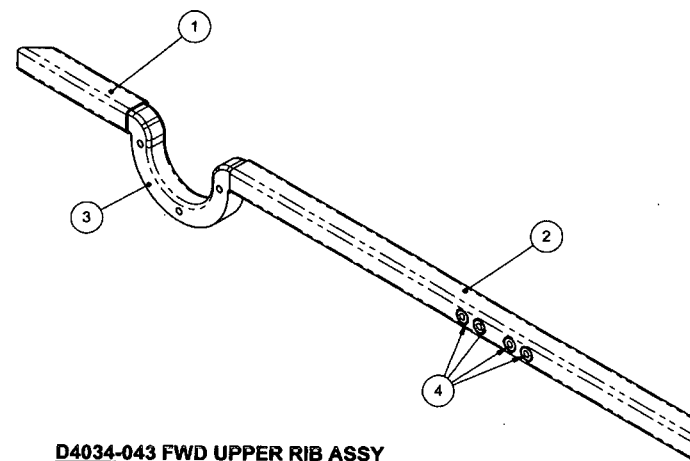
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(12x)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

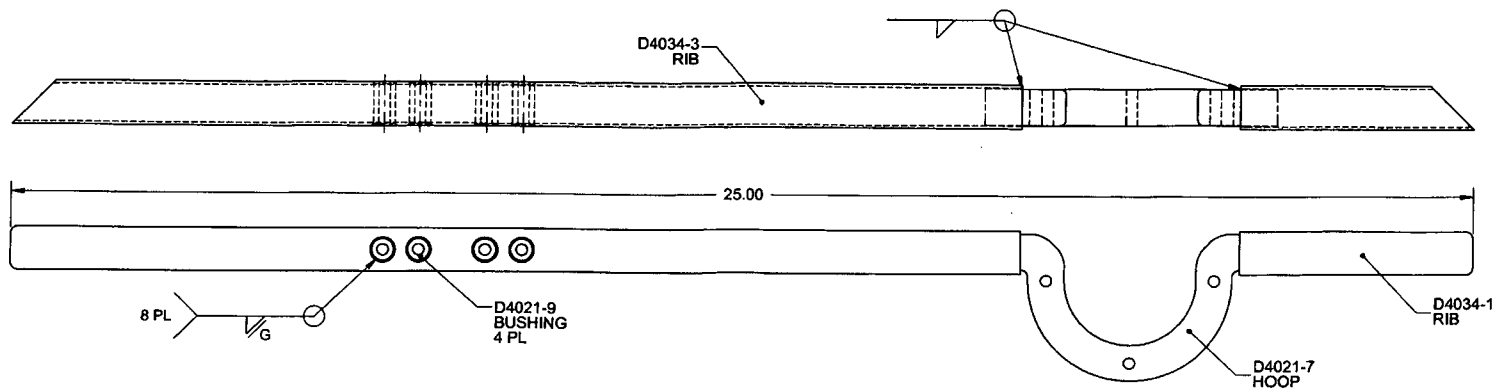


D4034-043 FWD UPPER RIB ASSY

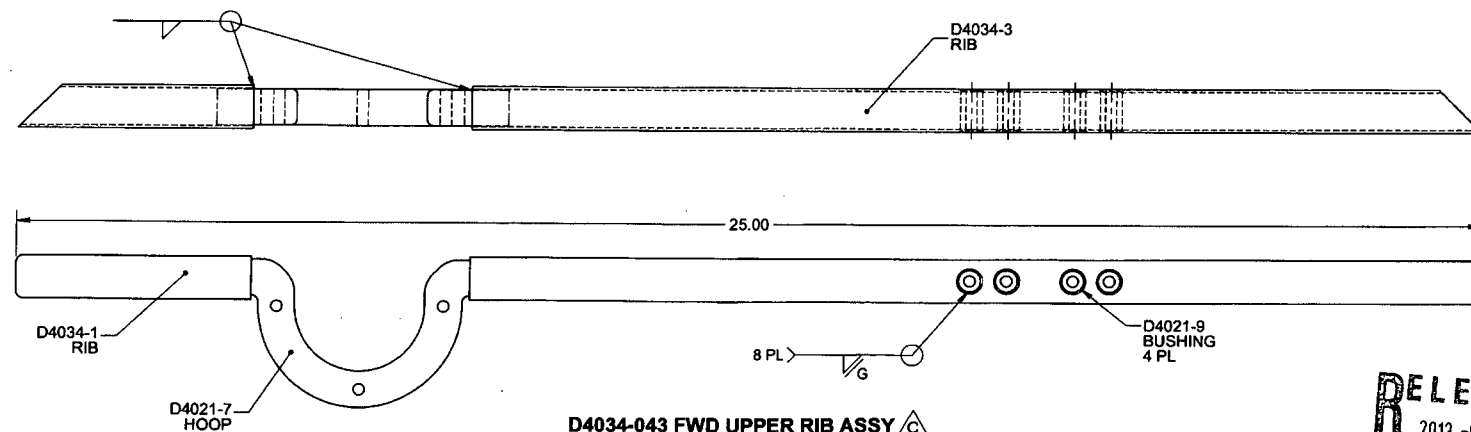
RELEASED
2013-06-20

1379563420151016

C	-043 REDESIGNED AS MIRROR IMAGE OF -041, -5 DELETED, D2327-3 DELETED, REASON PROP ARM NO LONGER OFFERED.		AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB		SC	10.12.20
A	NEW ISSUE		AJS	10.03.04
REV.		DESCRIPTION	BY	DATE
DESIGN		AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		AJS		
CHECKED		A.P.	DRAWING NO.	REV. C
MFG. APPR.			D4034	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.			UPPER RIB ASSY, BASKET BASE	NTS
DATE		13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT	



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

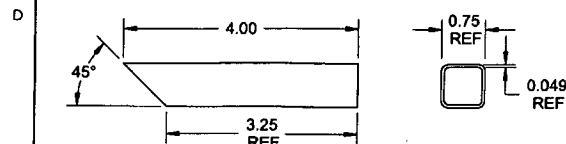
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

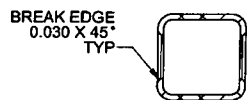
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DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	A.P.	D4034	SHEET 2 OF 3
APPROVED	A.P.	TITLE	SCALE
DE APPR.	A.P.	UPPER RIB ASSY, BASKET BASE	NTS
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2013-06-20
WMD

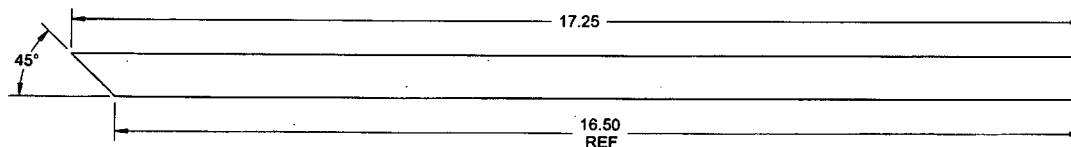
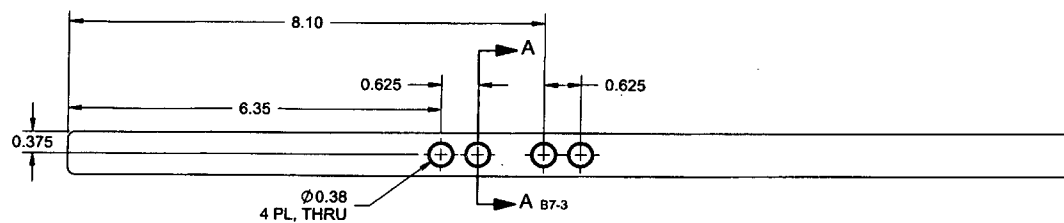
8 7 6 5 4 3 2 1



D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

RELEASED
2013-06-28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>AJS</i>	DRAWING NO. D4034	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	
DATE	13.03.13	NTS	

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8 7 6 5 4 3 2 1